

986T
Work Order ID 56747-1

March 8, 2010 9:03:03 AM

Page 1

Item ID: D2571

Accept

Revision ID:

Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010 Start Qty: 8.00

Required Date: 23/03/2010 Req'd Qty: 8.00

Reference: 10-03-08

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. 56747 Double check by: [Signature] 11-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets! 12-Machine Step No 2
per Folio FA051 and inspect per attached Dimension Sheets! 13-Machine Step No 3
per Folio FA051 and inspect

MWF 10/03/10

1 0

110

0.00

CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

Memo

0.00

Machine keyway as per dwg D2571 & D2572

DJA 10/03/11

1 0

120

0.00

QC2- Inspect parts off machine FAI-FAIB

QC

Quality Control

Memo

0.00

MWF 10/03/10

DJA 10/03/11

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56747

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:35

FINISH TIME: 9:05

OVEN TEMPERATURE: 320°

BR 10-3-12 D.

W/O:		WORK ORDER CHANGES					
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Work Order ID 56747

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Item ID: D2571

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd Out 205

Stop



Start Date: 10/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

8/10/12

(X)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location

0.00

433

10-3-12 SP (10)

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

10/03/16

QC

Memo

0.00

ME

Quality Control

10-3-12

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

March 8, 2010 9:03:02 AM

Page 1

Work Order ID: 56747



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 10/03/2010

Required Date: 23/03/2010

Comments: IPP: J102.10.02 Re-format: Change to Dwg Rev. D & incorporated
D2572 [KJL]

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	74.0000	8.0000			



Saddle Billet

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	74	
41960	-1	
46412	73	

7/10/10 10/03/10 8

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 56747
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440					
B	1.745	1.755		1.746					
C	3.495	3.505		3.496					
D	1.745	1.755		1.746					
E	7.990	8.010		8.004					
F	0.490	0.510		0.500					
G	0.257	0.262		0.258	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.494	0.498				
J	1.174	1.184		1.174	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.560				
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.492	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.870	3.874	3.874	3.874		
P	0.115	0.135		0.126	0.126	0.127			
Q	0.115	0.135		0.127	0.135				
R	0.240	0.260		0.247	0.248	0.250			
S	0.115	0.135		0.128	0.130				
T	0.178	0.198		0.188	0.188	0.188			
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.235				
W	0.115	0.135		0.125	0.120				
X	0.308	0.313		0.309					
Y	0.760	0.765		0.761					
Z	0.352	0.372		0.367					
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626					
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250				
AE	1.375	1.395		1.387	1.390				
AF	0.115	0.135		0.135	0.139				
AG	0.240	0.280		0.250	0.255				
AH	0.240	0.260		0.250	0.244				
AI	2.000	2.020		2.002	2.005				
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by:	DTJ
Date:	10/23/11

Audited by:	AS
Date:	10/23/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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